

Work Order ID 125697

125697

RUSH !!

Page 1

Item ID: D4149-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Lug Plate, Aft

Start Date: 10/21/2014 Start Qty: 40.00

40

Cust Item ID:

Required Date: 10/21/2014 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: MCS

Date: 14-10-21 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4149	C
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0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4149

Prog Rev: C

Dwg Rev: C

OPEN TO HOLES TO FINISH SIZE AS PER DWG ✓

Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

DAS
23
9-89

14-10-21

DAS
23
9-89

14-10-21

Work Order ID 125697

125697

Page 2

Tuesday, October 21, 2014 8:06:37 AM

Item ID: D4149-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Lug Plate, Aft

Start Date: 10/21/2014 Start Qty: 40.00

40

Cust Item ID:

Required Date: 10/21/2014 Req'd Qty: 40.00

40

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(40)

DAS
38
9-89
OCT 22 2014

150

Identify as per dwg & Stock Location: 81074 0.00

150

Packaging

Memo

0.00

Packaging

40x SP14-10-22

160

QC21- Final Inspection - Work Order Release 0.00

160

QC

Memo

0.00

Quality Control

14/10/23

SP14-10-22

Picklist Print

Tuesday, October 21, 2014 8:06:46 AM

Page 1

Work Order ID: 125697

125697

Parent Item: D4149-1

D4149-1

Parent Item Name: Crosstube Lug Plate. Aft

Start Date: 10/21/2014

Required Date: 10/21/2014

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 11.03.03 as per revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased		No		100	sf	325.5622	0.1355	6			
M304S11GA									**			DAS 23 88	14-10-21
304/316 0.125 Sheet													

Location

Loc Qty

Loc Code

MAT020

264.299

122521

27.3

M128254

83.13

M129972

153.869

TPI

61.2631604

M129545

61.2631604

129972

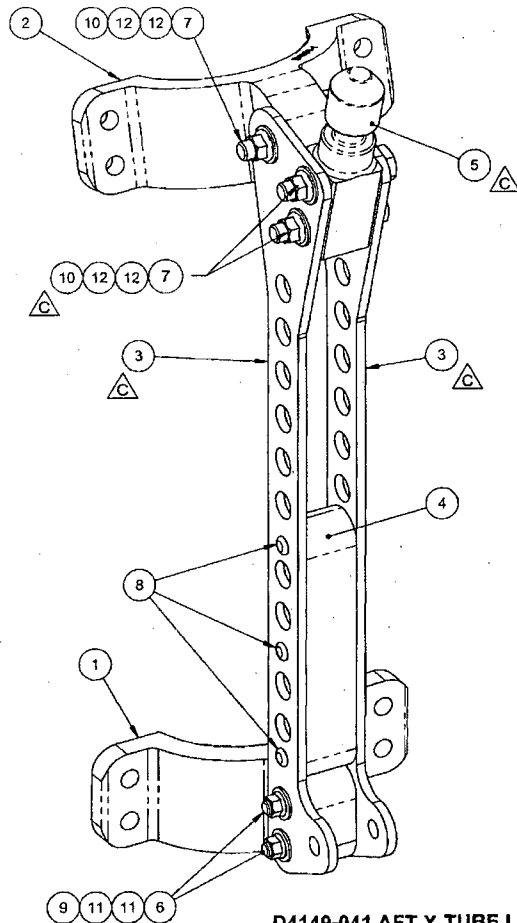
DART AEROSPACE LTD		Work Order:	175693
Description: Aft Crosstube Lug Plate		Part Number:	D4149-1
Inspection Dwg: D4149 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.131"	-		✓	Item 1
Ø0.191	+0.005/-0.001	0.193"	-		✓	
Ø0.257	+0.006/-0.001	0.258"	-		✓	
Ø0.38	+0.006/-0.001	0.38"	-		✓	
0.380	+/-0.010	0.384"	-		✓	
0.469	+/-0.010	0.469"	-		✓	
0.310	+/-0.010	0.312"	-		✓	
0.750	+/-0.010	0.750"	-		✓	
3.25	+/-0.030	3.25"	-		✓	
0.65	+/-0.030	0.65"	-		✓	
0.63	+/-0.030	0.63"	-		✓	
5.46	+/-0.030	5.46"	-		✓	
3.80	+/-0.030	3.80"	-		✓	
2.13	+/-0.030	2.13"	-		✓	
1.313	+/-0.010	1.313"	-		✓	
0.625	+/-0.010	0.627"	-		✓	
0.375	+/-0.010	0.377"	-		✓	
1.175	+/-0.010	1.174"	-		✓	
0.752	+/-0.010	0.752"	-		✓	
1.588	+/-0.010	1.588"	-		✓	
1.587	+/-0.010	1.587"	-		✓	
11.15	+/-0.030	11.15"	-		✓	Item 8
0.750	+/-0.010	0.754"	-		✓	
1.55	+/-0.030	1.55"	-		✓	
1.12	+/-0.030	1.12"	-		✓	
8.42	+/-0.030	8.42"	-		✓	
2.70	+/-0.030	2.70"	-		✓	
0.125	+/-0.010	0.117"	-		✓	
Ø0.252	+0.003/-0.000	0.253"	-		✓	

Measured by: DAS 23 9-89		Audited by: DAS 38 9-89		Preliminary Approval:	
Date: 14-10-21		Date: OCT 22 2014		Date:	

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	12.02.01	Dimensions updated per Dwg Rev C	KJ	



D4149-041 AFT X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.21 lbs

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	2	AN3C12A	BOLT
7	3	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	2	MS21043C3	NUT
10	3	MS21043C4	NUT
11	4	NAS1149C0332R	WASHER
12	6	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO **125697MCS**
14-10-21

RELEASED
2011-02-26
JAN

C	HOLE DIA CHANGED TO 0.250" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, D7-2)	SC	11.02.22
B	MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D8-3); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, WITHOUT PERMISSION FROM DART AEROSPACE LTD.	

8

7

6

5

4

3

2

1

D

C

B

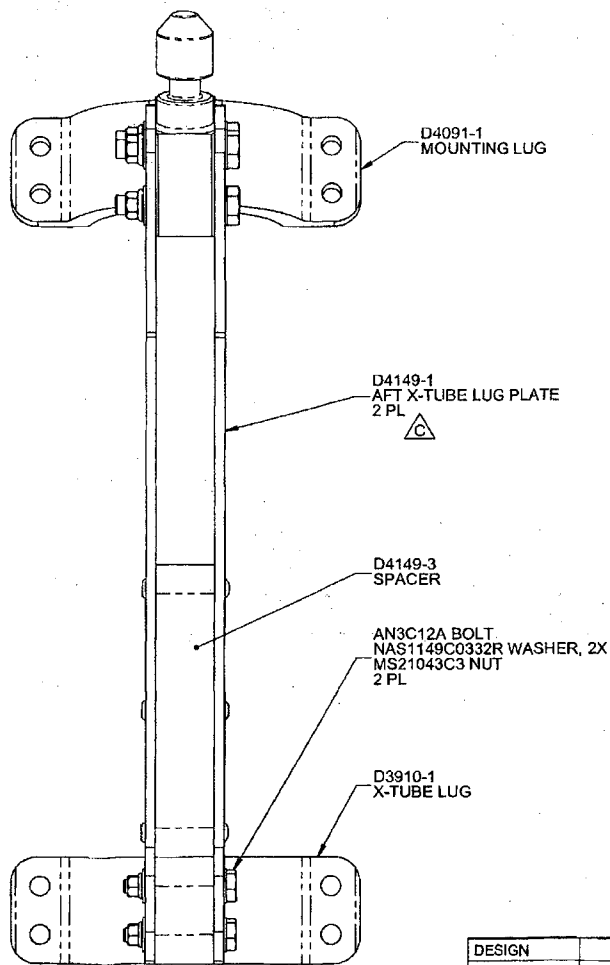
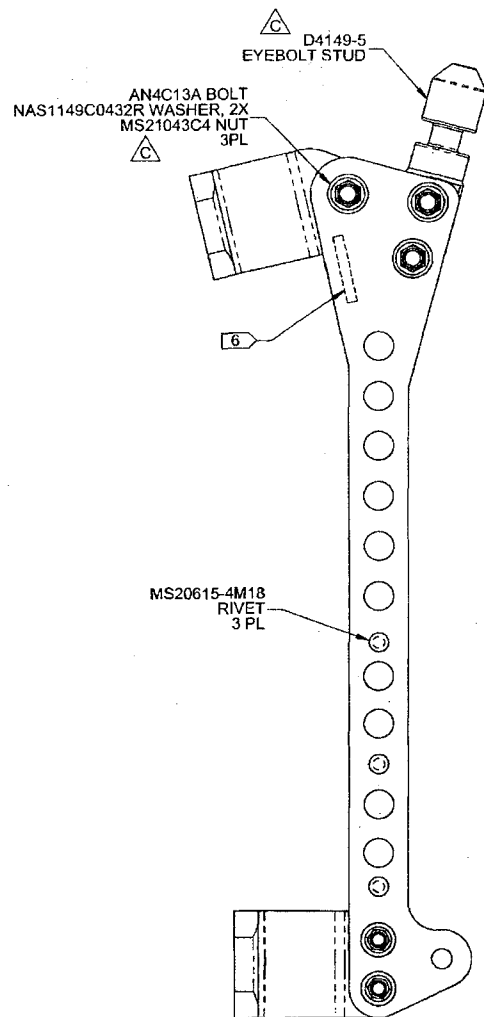
A

D

C

B

A



D4149-041 AFT X-TUBE LUG ASSY

RELEASED
2011-02-24
MP

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
DATE	11.02.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES, OR COPIED OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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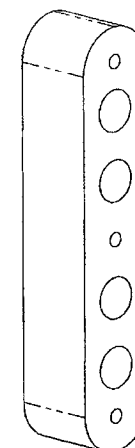
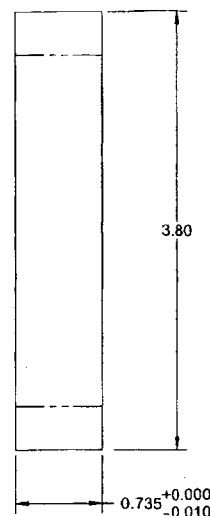
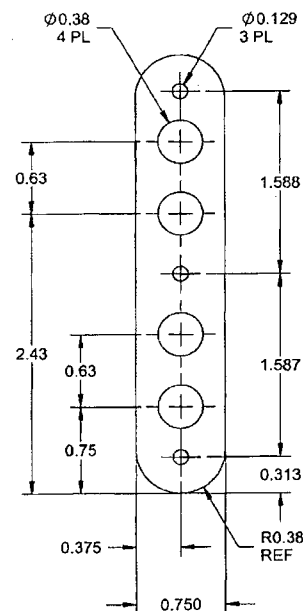
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4

3

2

1



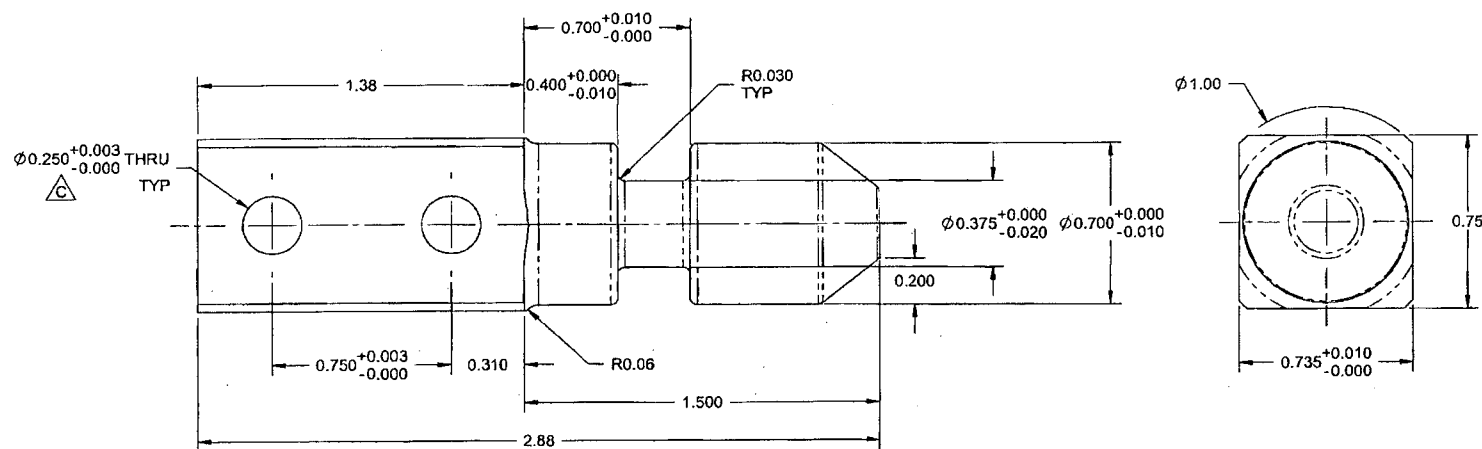
D4149-3 SPACER

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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D4149-5 EYEBOLT STUD

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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